

Date: Friday, 18/07/2008 1:19:56 PM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	:: SUPPORT PLATE LH		
Job Number	40662	Part Number	:: D36973		
Estimate Number	13283	Drawing Number	:: D3697 REV B		
P.O. Number	:	Project Number	:: N/A		
This Issue	18/07/2008	S.O. No.	::		
Prsht Rev.	NC	Drawing Revision	:: B		
First Issue	/ /	Material	::		
Previous Run	38860	Due Date	08/08/2008	Qty:	10 Um: Each
Written By	:				
Checked & Approved By	JLO 08.2.18				
Comment	Est Rev:A 08-04-25 new issue DD verified by:EC Est Rev:B 08-07-14 revB as per dwg DD verified by:ec				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S050	6061-T6 .050 Sheet	
		Comment: Qty.: 0.4797 sf(s)/Unit Total : 4.7975 sf(s) 6061T6 aluminium sheet .050" thick (M6061T6S050) Batch: 104186 RB 8-7-23	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3697 Dwg Rev: B RB 8-7-23 Prog Rev: B ***grain direction along 3.44" *** 2- Deburr if necessary	(Pw) →
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		HB 8-7-23	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	8
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	(11)
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Bend as per Dwg D3697	EBO8/07/30 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3697-3 PAR #: plt Fault Category: Prod/fm ass. Mat & Smth NCR: Yes No DQA: D Date: 08/11/23
 - (412-776-011) QA: N/C Closed: D Date: 08/10/24

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/7/30	20	During QC inspection found 3 parts with the Ø.098" hole size at Ø.108" RC incorrect set off set.	<u>J</u> 10/11/22	water Set breaker all ready Replace Pro to take taking Holidays. Stop and Destroy Qty <u>13</u>	SAD 08/07/30 Sign for 08/14/30	<u>J</u>	<u>J</u>	<u>S</u> 08/07/30
					HB S 08/07/30			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE LH

Job Number: 40662

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



S08/10/22 (10)

Comment: INSPECT WORK TO CURRENT STEP

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-counter sink hole as per dwg D3697

8.0 QC5

INSPECT WORK TO CURRENT STEP



E08/10/22 (10)

S08/10/22 (10)

Comment: INSPECT WORK TO CURRENT STEP

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

L08/10/22 (10)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/24 (10)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



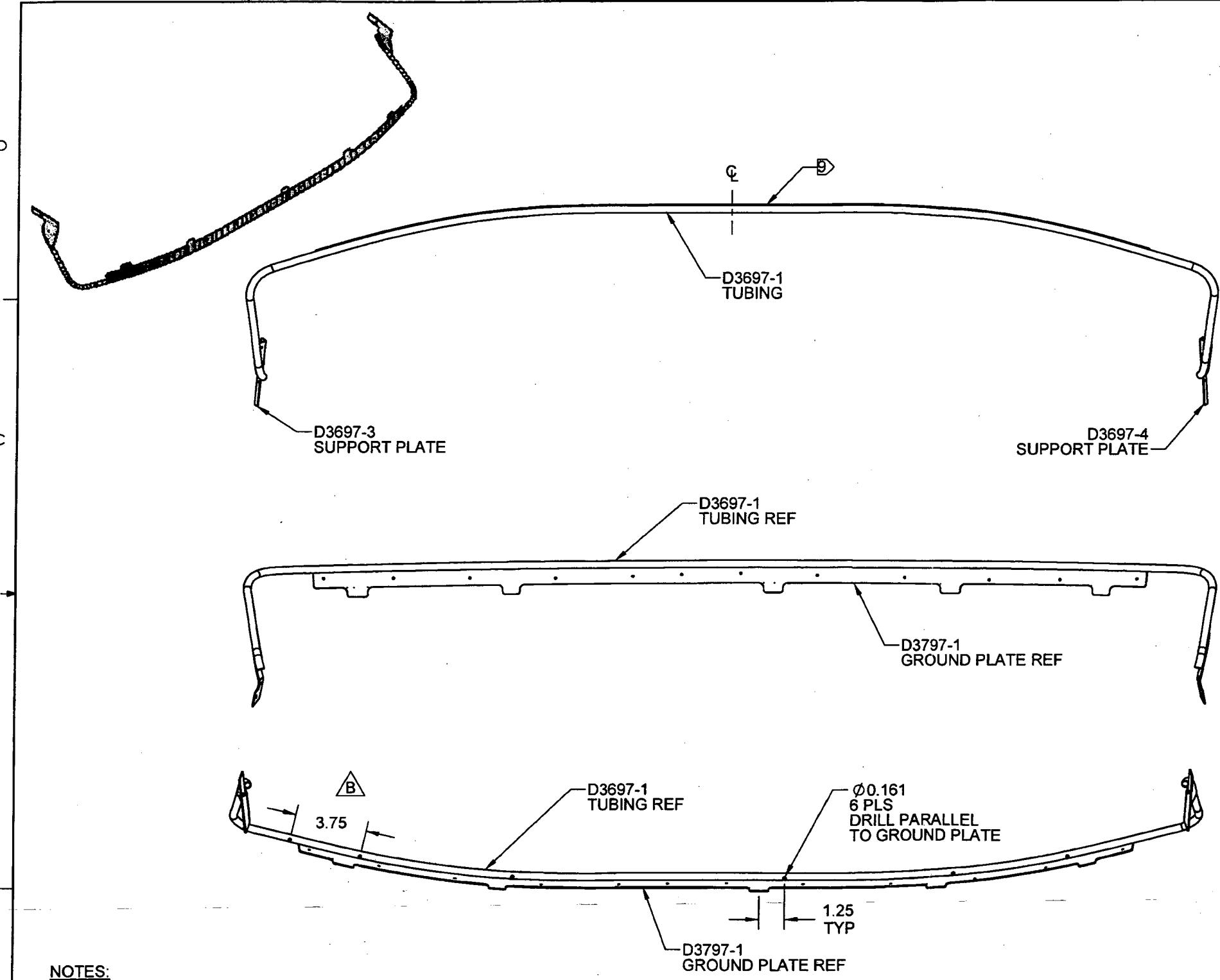
MUR 08-1023

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.55 lbs
- 8) LOCATE D3697-3/4 ON D3697-1 USING DT9009 WELDING JIG
- 9) CENTER D3797-1 GROUND PLATE ON D3697-1 TUBING

D3697-041 TUBE ASSEMBLY

PART LIST

QTY	PART NUMBER	DESCRIPTION
-041	X D3697-041	TUBE ASSEMBLY
1	D3697-1	TUBING
1	D3697-3	SUPPORT PLATE
1	D3697-4	SUPPORT PLATE
1	D3797-1	GROUND PLATE

B
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *4006*

B	REMOVE POWDER COAT & MASKED HATCHED AREAS. SHEET 1 ZONE A,8; ADD Ø0.161 HOLE. SHEET 1 ZONE B,7	RF	08.06.02
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>EZ</i>	D3697	SHEET 1 OF 3
APPROVED	<i>LM</i>	TITLE	SCALE
DE APPR.	<i>M</i>	TUBE ASSEMBLY	NTS
DATE	08.06.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

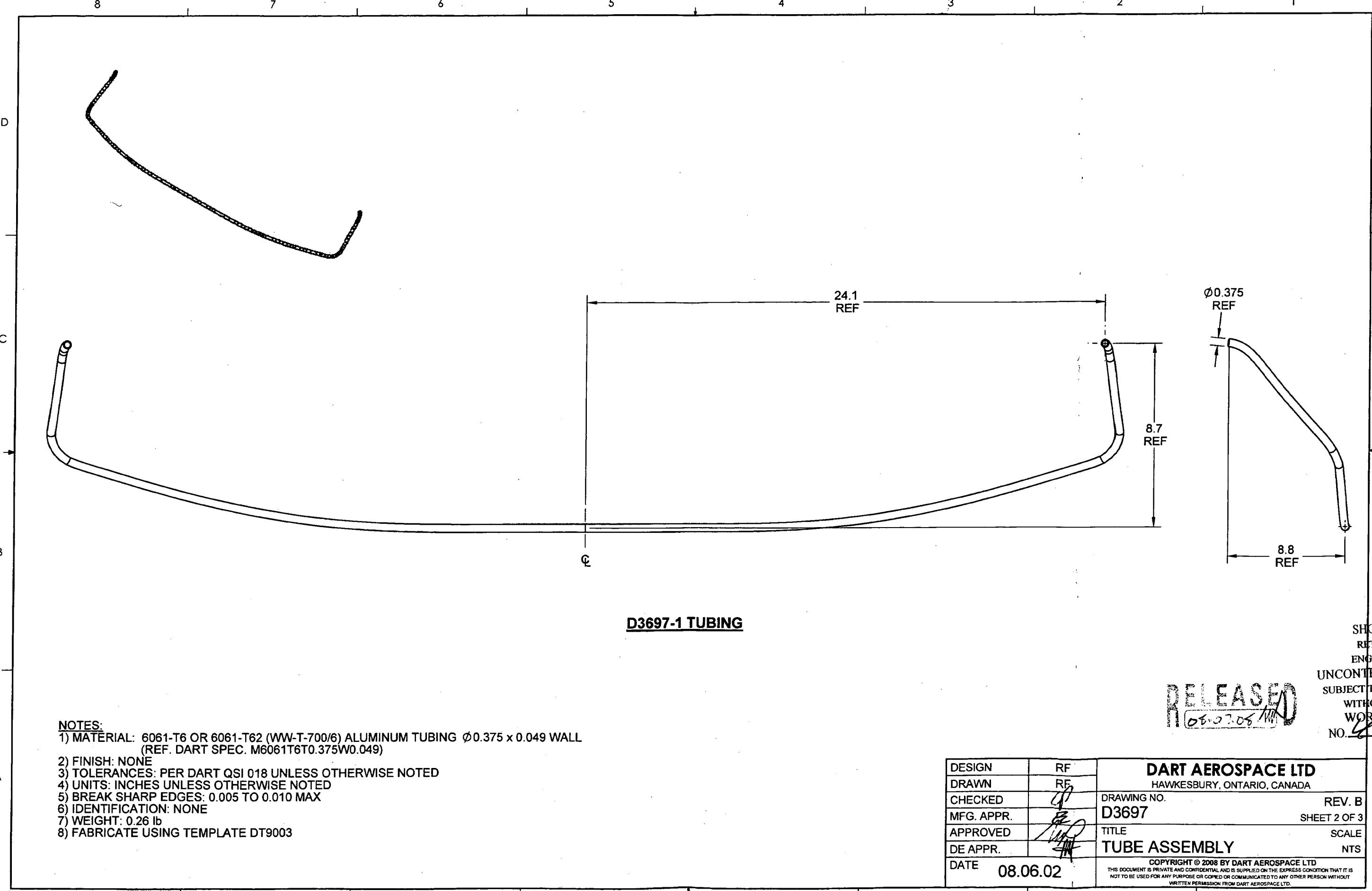
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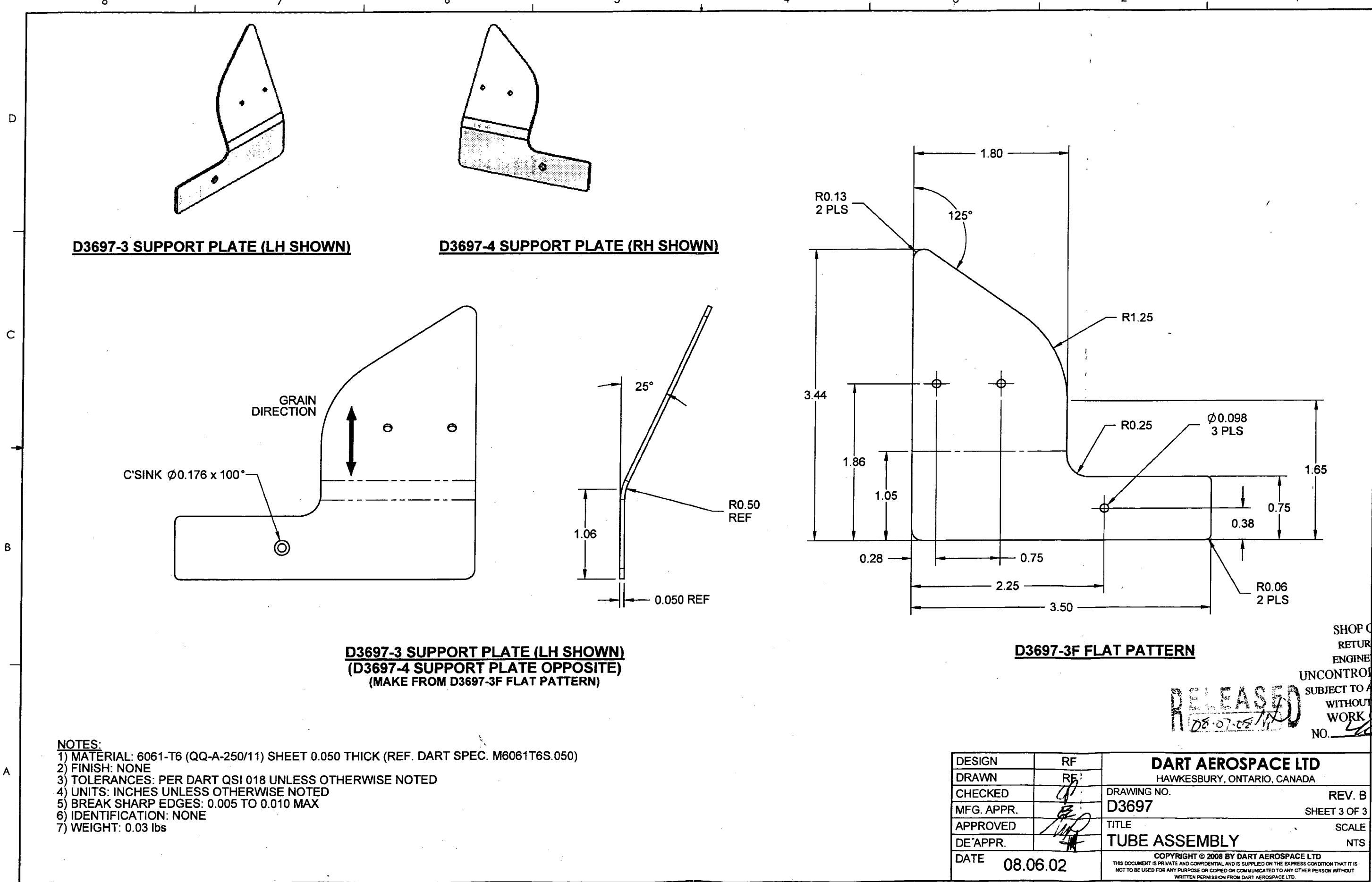
D

C

B

RELEASED
08-07-08 LM





DART AEROSPACE LTD	Work Order:	40660
Description: SUPPORT PLATE L H	Part Number:	D3691-3
Inspection Dwg: D3691-3 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: HS	Audited by: C	Prototype Approval: N
Date: 8-7-23	Date: 08/07/23	Date: 7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	